

Date: Wednesday, 27/08/2008 3:14:18 PM
User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : WEBBING TIDY
Job Number : 41645
Estimate Number : 11381
P.O. Number :
This Issue : 27/08/2008 S.O. No. :
Prsht Rev. : NC Part Number : D32153
First Issue : 27/08/2008 Type : SMALL /MED FAB Drawing Number : D3215 REVD
Previous Run : 39718 Project Number : N/A
Material :
Due Date : 10/09/2008 Qty: 20 Um: Each
Written By :
Checked & Approved By :
Comment : Est. A 04.01.06 New issue KJ/RF
Est Rev:B Now on Waterjet 06-07-03 JLM
est rev C ecn 940 07.06.12 EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M5052H32S040 5052-H32 .040 Sheet



Comment: Qty.: 0.0271 sf(s)/Unit Total : 0.5418 sf(s)
5052-H32 .040 Sheet
Material: 5052-H32 (QQ-A-250/8) 0.040" thick
(M5052H32S.040)
Identify for D3215-3A
Batch: 104921 B 8-8-27

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET
1-Cut as per Dwg D3215 (D3215-3A)
Dwg Rev: B
Prog Rev: B

B 8-8-27

30

2-Deburr if necessary

3-Identify as D3215-3A

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



B 8-8-27



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

S



counter

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 27/08/2008 3:14:18 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEBBING TIDY

Job Number: 41645

Part Number: D32153

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

5.0	M5052H32S040	5052-H32 .040 Sheet
-----	--------------	---------------------



Comment: Qty.: 0.0084 sf(s)/Unit Total: 0.1680 sf(s)
5052-H32 .040 Sheet
Batch: M102723

08/09/02

6.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Cut D3215-3B (2.130" x 0.530") as per dwg D3215

2-Deburr

3-Identify as D3215-3B

08/09/02 (30)

7.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

S 08/09/02 (430)

8.0	BRAKE NC	NC BRAKE
-----	----------	----------



Comment: NC BRAKE

Form D3215-3A as per Dwg D3215

S 08/09/03 (30)

9.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

S 08/09/03 (30)

10.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
------	-------------	------------------------------



Comment: LARGE FABRICATION RESOURCE 1

Weld D3215-3 by joining D3215-3A and D3215-3B as per Dwg D3215 and QSI 004
A/R AL ROD BATCH: M106330

PD 08-09-03 (30)

Identify as D3215-3

Grind flush

→ SAN 08/09/04 (30)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3215-3 PAR #: NA Fault Category: Prod / Pro. Mgr. NCR: (Yes) No DQA: AD Date: 08/09/05
D3215-041/043
 Resolution: D412-702 Disposition: _____ QA: N/C Closed: WD Date: 08/09/05

NCR: <u>41645</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>8/9/04</u>	<u>100</u>	<u>6 parts have defects from welding. welder went through the mat. while welding RC Too much heat</u>	<u>AD</u>	<u>Scrap & destroy qty (56) no replace</u>	<u>PD 08-09-04</u>	<u>08/09/04</u>	<u>AD</u>	<u>08/09/04</u>

NOTE: Date & initial all entries

Date: Wednesday, 27/08/2008 3:14:19 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEBBING TIDY

Job Number: 41645

Part Number: D32153

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

QC9

VISUAL WELDING INSPECTION



B.E
pl 08-09-04



Comment: VISUAL WELDING INSPECTION

12.0

QC5

INSPECT WORK TO CURRENT STEP



S o d o l o r



counters

Comment: INSPECT WORK TO CURRENT STEP

13.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

pl

08-09-04

(24)

14.0

POWDER COATING

POWDER COATING



m 102316



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

START TIME:

9:15

OVEN TEMPERATURE:

320°

FINISH TIME:

9:45

FL 08/09/05

(24)

15.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-h

08/09/05

(24X)

16.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

pl 08/09/05

(24)

17.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/09/05

Job Completion



u 08/09/05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

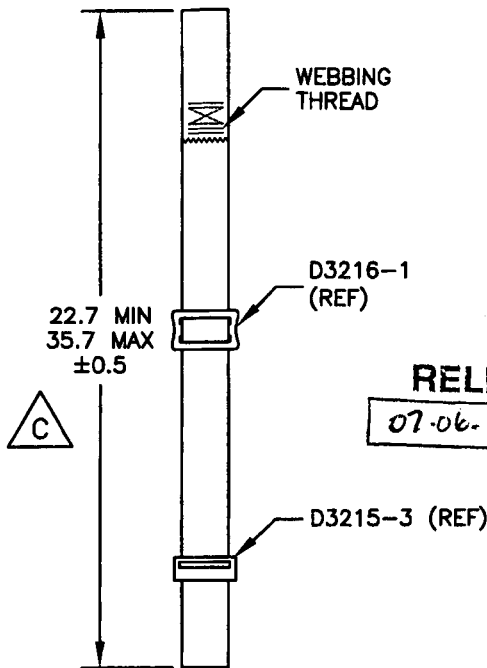
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

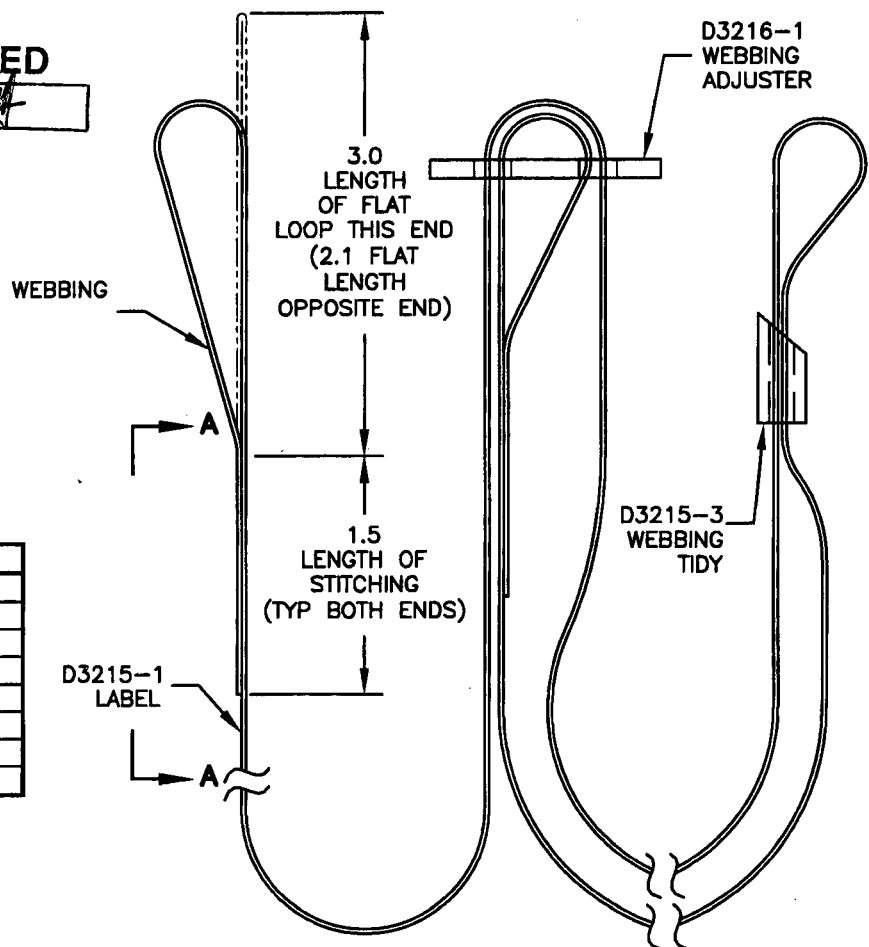
DART

DESIGN <i>GP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3215	REV. D SHEET 1 OF 3
DATE 07.03.27		TITLE BELT ASSEMBLY	SCALE NTS
A	03.09.19	NEW ISSUE	
B	04.01.12	AS MANUFACTURED; ADD TOLERANCE	
C	04.03.05	REDUCE LENGTH; CLARIFY STITCHING	
D	07.03.27	ADD WEBBING SUPPLIER; ADD LABEL THREAD AND MATERIAL; IN VIEW A-A, 1.4 WAS 1.8; ADD -3A AND -3B; UPDATE TOLERANCES	



PARTS LIST:

QTY	P/N	DESCRIPTION
X	D3215-041	BELT ASSEMBLY
AS REQ'D	SEE NOTE 1	WEBBING
AS REQ'D	SEE NOTE 1	WEBBING THREAD
AS REQ'D	SEE NOTE 1	LABEL THREAD
1	D3215-1	LABEL
1	D3215-3	WEBBING TIDY
1	D3216-1	WEBBING ADJUSTER

**D3215-041 BELT ASSEMBLY:**

- 1) MATERIAL: WEBBING = LAGRAN CANADA INC. 26472, 1.8 WIDE x 0.05 THICK BLACK POLYESTER WEBBING, CERTIFIED TO FAR 29.853A3, TENSILE STRENGTH 5700 lb MIN
OR BELT TECH CANADA INC. 27039, 1.8 WIDE x 0.05 THICK BLACK POLYESTER WEBBING, CERTIFIED TO FAR 29.853A3, TENSILE STRENGTH 6000 lb MIN

WEBBING THREAD = V-T-295 TYPE II CLASS A SIZE 3, BLACK NYLON THREAD
LABEL THREAD = V-T-295 TYPE II CLASS A SIZE F, BLACK NYLON THREAD

- 2) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
4) SEE SHEET 3 FOR VIEW A-A

SHOP COPY
RETURN TO
ENGINEERING
INCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *4445*

Copyright © 2003 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

DART

DESIGN GP	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CE	APPROVED H	DRAWING NO. D3215	REV. D SHEET 2 OF 3
DATE 07.03.27	TITLE BELT ASSEMBLY		SCALE NTS

D3215-043 BELT ASSEMBLY:

- 1) MATERIAL:
WEBBING = LAGRAN CANADA INC. 26472, 1.8 WIDE
x 0.05 THICK BLACK POLYESTER WEBBING,
CERTIFIED TO FAR 29.853A3, TENSILE
STRENGTH 5700 lb MIN
OR
BELT TECH CANADA INC. 27039, 1.8 WIDE
x 0.05 THICK BLACK POLYESTER WEBBING,
CERTIFIED TO FAR 29.853A3, TENSILE
STRENGTH 6000 lb MIN
WEBBING THREAD = V-T-295 TYPE II CLASS A SIZE 3,
BLACK NYLON THREAD
LABEL THREAD = V-T-295 TYPE II CLASS A SIZE F,
BLACK NYLON THREAD
- 2) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE
NOTED.
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED.
- 4) SEE SHEET 3 FOR VIEW A-A



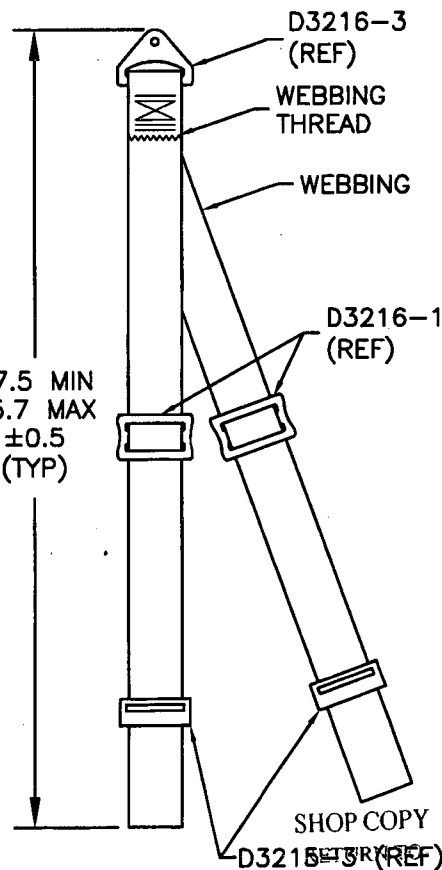
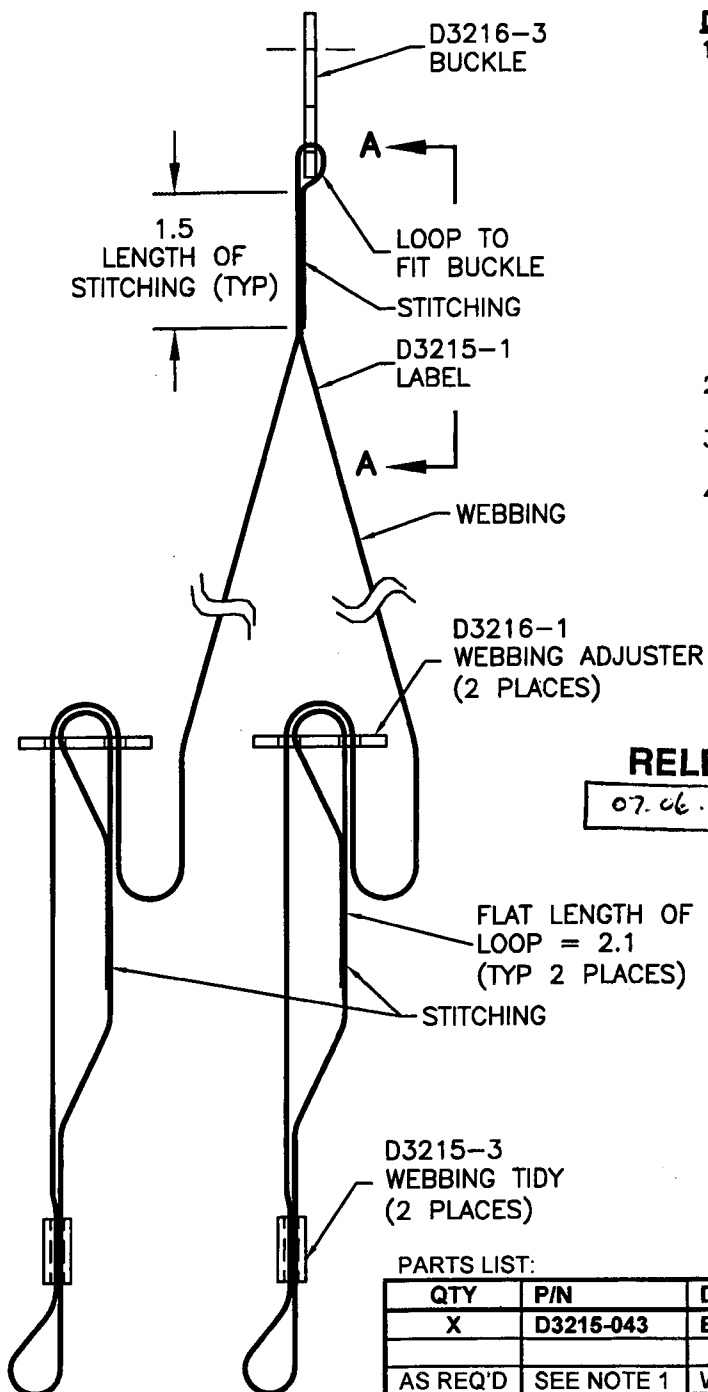
WEBBING THREAD = V-T-295 TYPE II CLASS A SIZE 3,
BLACK NYLON THREAD
LABEL THREAD = V-T-295 TYPE II CLASS A SIZE F,
BLACK NYLON THREAD

RELEASED

07.06.07



27.5 MIN
45.7 MAX
±0.5
(TYP)

**PARTS LIST:**

QTY	P/N	DESCRIPTION
X	D3215-043	BELT ASSEMBLY
AS REQ'D	SEE NOTE 1	WEBBING
AS REQ'D	SEE NOTE 1	WEBBING THREAD
AS REQ'D	SEE NOTE 1	LABEL THREAD
1	D3215-1	LABEL
2	D3215-3	WEBBING TIDY
2	D3216-1	WEBBING ADJUSTER

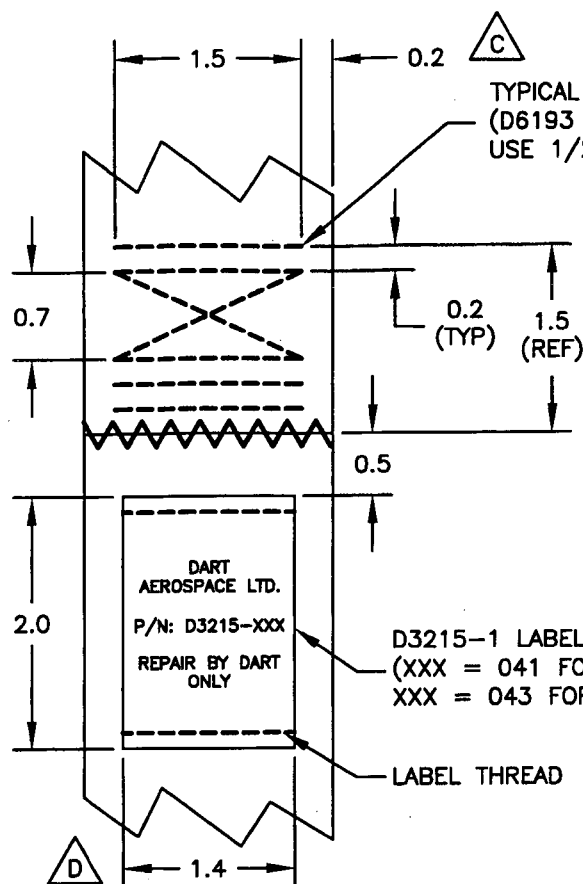
SHOP COPY
D3215-043 (REF)
ENGINEERING
CONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 41045

Copyright © 2003 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

DART

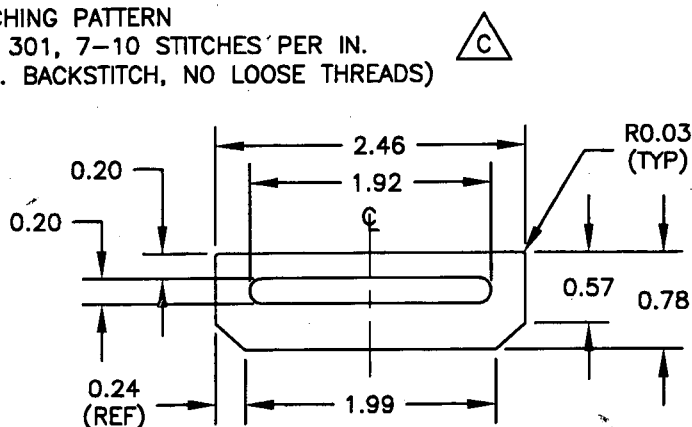
DESIGN <i>GP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3215	REV. D SHEET 3 OF 3
DATE 07.03.27	TITLE HARNESS ASSEMBLY		SCALE 3:2

**VIEW A-A****D3215-1 LABEL:**

- 1) MATERIAL: WHITE TYVEK OR WHITE POLYESTER WHICH MEETS FMVSS 302
- 2) USE 1/8 BLACK LETTERING
- 3) CENTER ON BELT WIDTH

RELEASED07.06.07 *[Signature]***GENERAL NOTES:**

- 1) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED



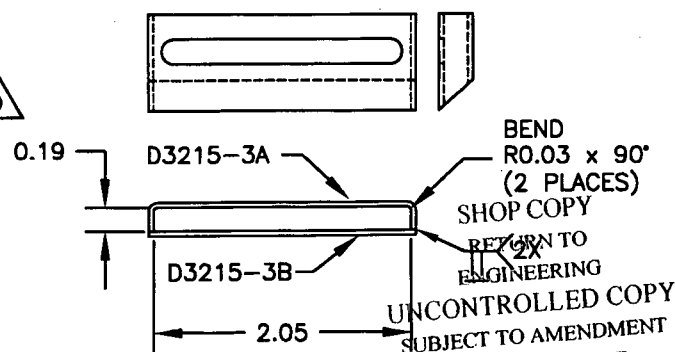
R0.03 (TYP)

D3215-3B

2.13

D3215-3A/-3B NOTES:

- 1) MATERIAL: 5052-H32 ALUMINUM SHEET, 0.040 THICK PER QQ-A-250/8 OR AMS 4016 (REF DART SPEC. M5052H32S.040)
- 2) BEND D3215-3A PER D3215-3

**D3215-3 NOTES:**

- 1) WELD PER DART QSI 004
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT BLACK SANDTEX (4.3.5.7)
PER DART QSI 005 4.3

Copyright © 2003 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.